

ASAP 6

Work Order ID 64541

December 21, 2010 2:30:23 PM



Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Fwd

Start Date: 12/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00

Customer: CU-DAR001

Reference: RMA RA110139 +REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D212-664-141	Rev D
--------------	-------

100

0.00



QC

Memo

0.00

Quality Control

INSPECT RA110139  
D212-664-101 B60522

See RMA & UCR report.

11-01-06

110

0.00



Crosstubes

Crosstubes

Memo

0.00

-BUFF CORROSION  
-ACID ETCH AND ALODINE  
-RE-PRIME UNDER SUPPORTS, REINSTALL SUPPORTS

allow primer to dry for  
4 hrs min then assemble

0.00

11-1-06

11-01-10

115



Packaging

Packaging

Memo

0.00

PACKAGE -RETURN TO CUSTOMER

Outsource  
LPI per JST

PD 13250

C 11/10/11  
C 11/10/10 (X)  
C 11/1/10 C

L 116 -> QCS

Sulali

(X)

W/O: 64541		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-01-10	110	prime inside of original supports leave exterior s/s	ET	10-01-10	x2	h 11-01-11	S 11/01/11	
11-01-10	110	install new clamps MS21920-25 x4 install new rubber strips D3595-063-450	ET	11-01-10		h 11-01-11	S 11/01/11	

Part No: D212-664-101 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 64541**

December 21, 2010 2:30:23 PM

Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12

A 18-01-14

**L Lacelle**

**From:** Bill Beckett [bbeckett@dartaero.com]  
**Sent:** December 20, 2010 12:55 PM  
**To:** 'Peggy McDonald'; swillems@dartaero.com; 'L Lacelle'  
**Cc:** 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'  
**Subject:** RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

Bill

**From:** Peggy McDonald [mailto:peggy@darths.com]  
**Sent:** December 20, 2010 12:48 PM  
**To:** Bill Beckett  
**Cc:** Marc Bellavance  
**Subject:** Crosstube corrosion from Expedition  
**Importance:** High

*- Buff corrosion  
 - acid etch  
 - alodine  
 - reassemble, prime under supports*

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.  
 (removal of the surface corrosion, acid etch and alodine)

**PLEASE NOTE : the customer will do their own priming right before paint.**

These can be returned to them early in the new year.  
 I recommend a MISC no charge PO to be sent to DAS.  
 Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

Peggy

*64541  
 547  
 60522  
 60450*

**PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside,  
 California 92056**

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12/20/10

# Work Order ID 64541



Page 1

December 8, 2010 8:52:04 AM

Item ID: D212-664-101

Accept



Setup Start



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Stop



Item Name: Crosstube Fwd

Start Date: 12/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA110139

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D212-664-141

Rev D

100

0.00



QC

Memo

0.00

Quality Control

INSPECT RA110139

110

0.00

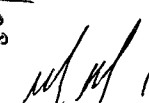


Crosstubes

Memo

0.00

Crosstubes

 10 12 08 ①Verified by:  10/12/08

**Work Order ID 64541**

Page 2

December 8, 2010 8:52:04 AM

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



# LIQUID PENETRANT TEST REPORT

P- 15201

CLIENT	DART Aerospace	DATE	JAN. 10. 2011	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-11-2008	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST HAWKES BURY, CN.	PO/VO No.		WORK LOCATION	Hawkesbury Plant			
PROJECT	F.P. I.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2005			
ITEM(S) EXAMINED	6 CROSS TUBES 2 ENGINE MOUNTS							

JOB DESCRIPTION	PROCEDURE No. LT-002	REV./DATE	2008	TECHNIQUE No. LT-002	REV./DATE	2008
PART NO.	MATERIAL ALUMINUM THICKNESS VARIOUS					
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION COPIED OUT 100% EXTERNAL					

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAINT FLUX
PENETRANT	2 LG 7 MINIMUM DWELL TIME 45 10 MIN.
PENETRANT REMOVER	H2O MINIMUM DRY TIME >10 MIN.
DEVELOPER	SDS2 MINIMUM DWELL TIME 10 MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
TEST SURFACE	

SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS-	( <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)
1 - CROSS TUBE - W.C. 63783 ✓ 1 - CROSS TUBE - W.C. 63984 ✓ 1 - CROSS TUBE - W.C. 63575 ✓ 1 - CROSS TUBE - W.C. 63524 ✓ 1 - CROSS TUBE - W.C. 64541 ✓ 1 - CROSS TUBE - W.C. 64547 ✓ 1 - REPLACEMENT ENGINE MOUNT - W.C. 63456 - D3667-1 ✓ 1 - ADD D3667-3 ✓	

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**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	PRINT: <u>Sam Titley</u> SIGNATURE: <u>[Signature]</u>
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT):	NAME INITIALS
1 <sup>ST</sup> TECHNICIAN	2 <sup>ND</sup> TECHNICIAN
CGSB LEVEL <u>E</u> SNT LEVEL <u>2</u>	CGSB LEVEL <u>2</u> SNT LEVEL <u>2</u>
CGSB REG. No. <u>1006</u>	CGSB REG. No. <u>1006</u>

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

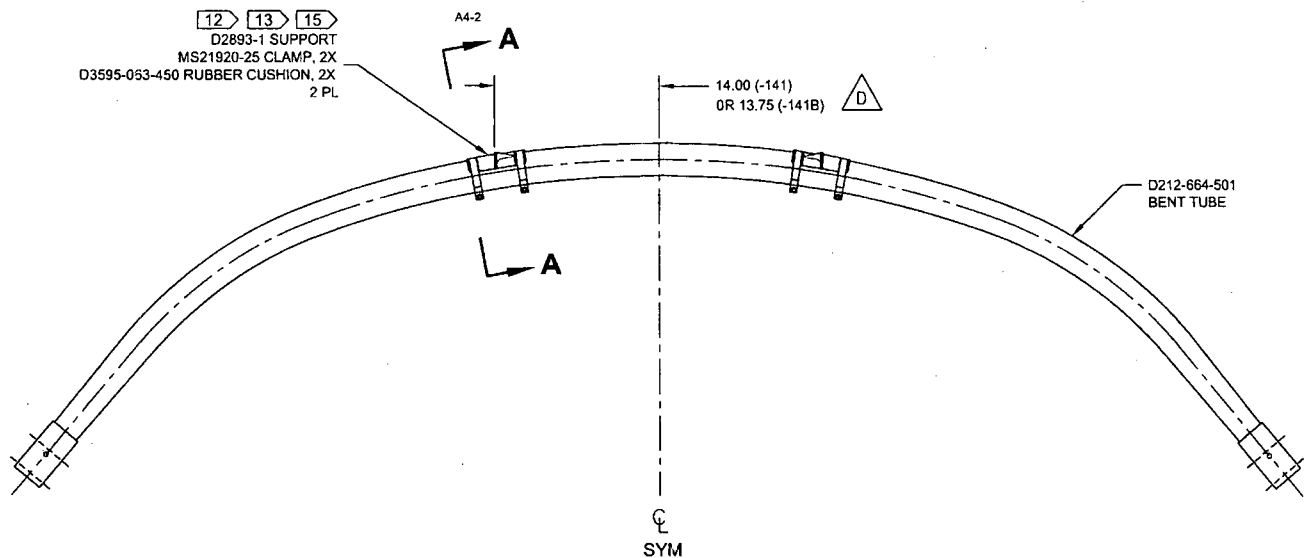
# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)  
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS  
6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF  
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE  
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR  
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND  
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT  
HAS NOT BOTTOMED-OUT AFTER TORQUING.

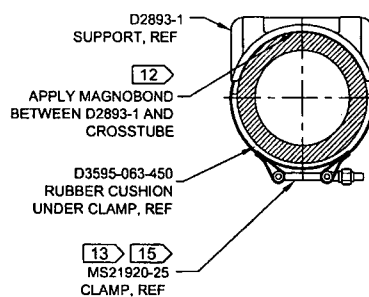
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. D
MFG. APPR.	10	D212-664-141	SHEET 1 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	CROSSTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

64541  
**RELEASED**  
2009-10-29  
M





**D212-664-141/-141B**  
**ASSEMBLY DETAIL**

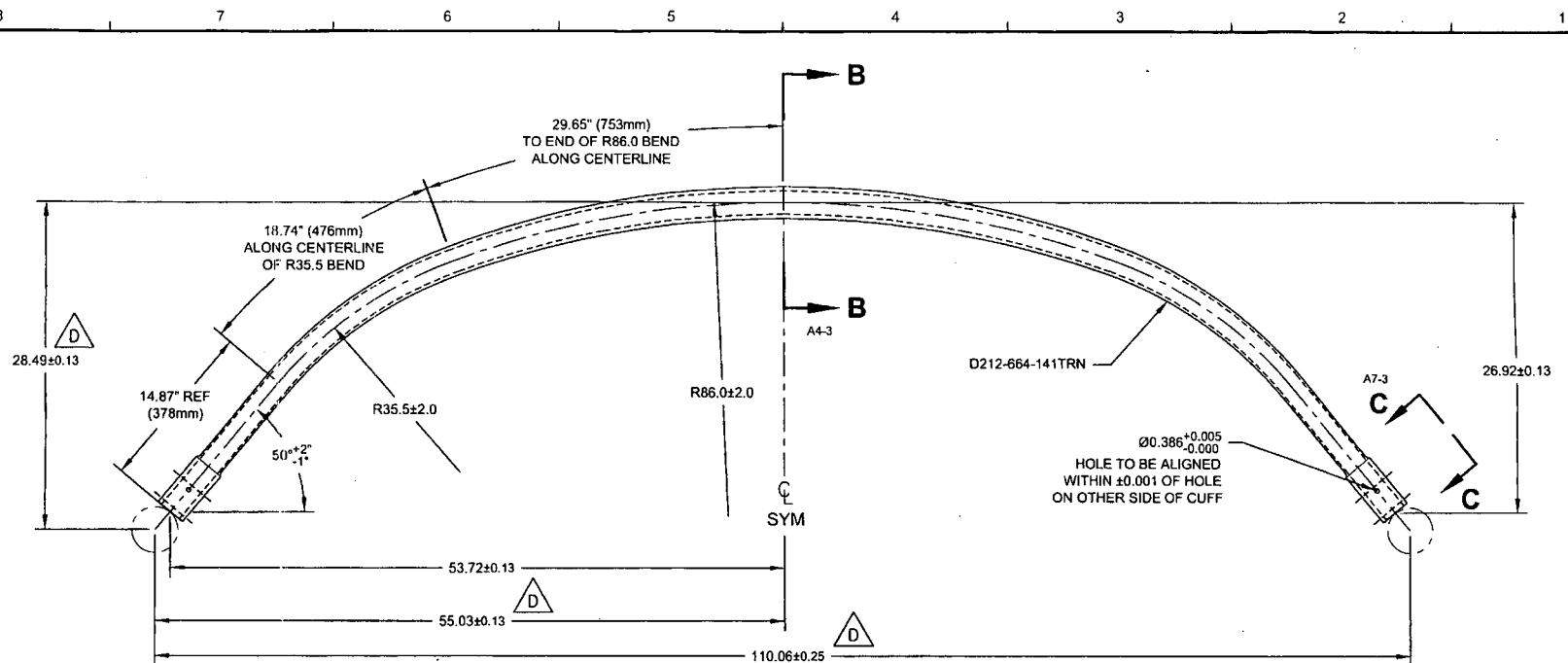


**SECTION A-A**  
SCALE 4X

**RELEASED**  
2009-10-29

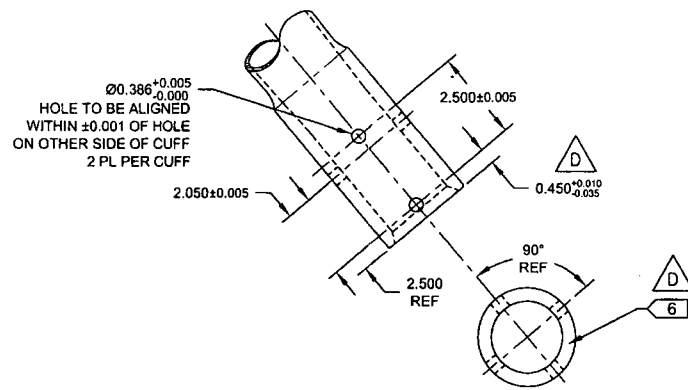
64541

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	SS	D212-664-141	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	H	XTUBE ASS'Y (205/212/412 HI FWD)	HTG
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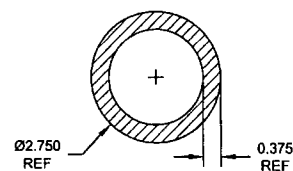


**D212-664-501**  
**BENDING AND DRILLING DETAIL**

10 D



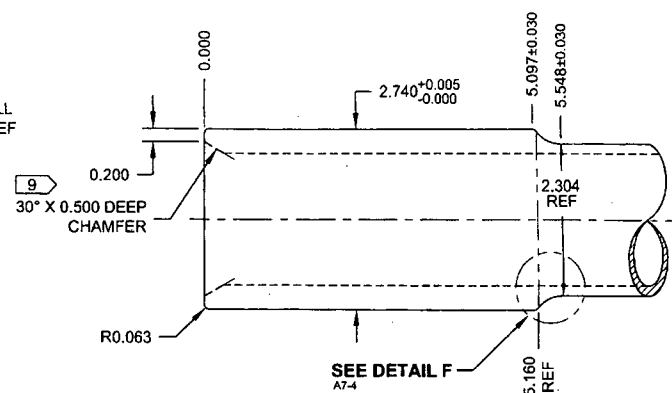
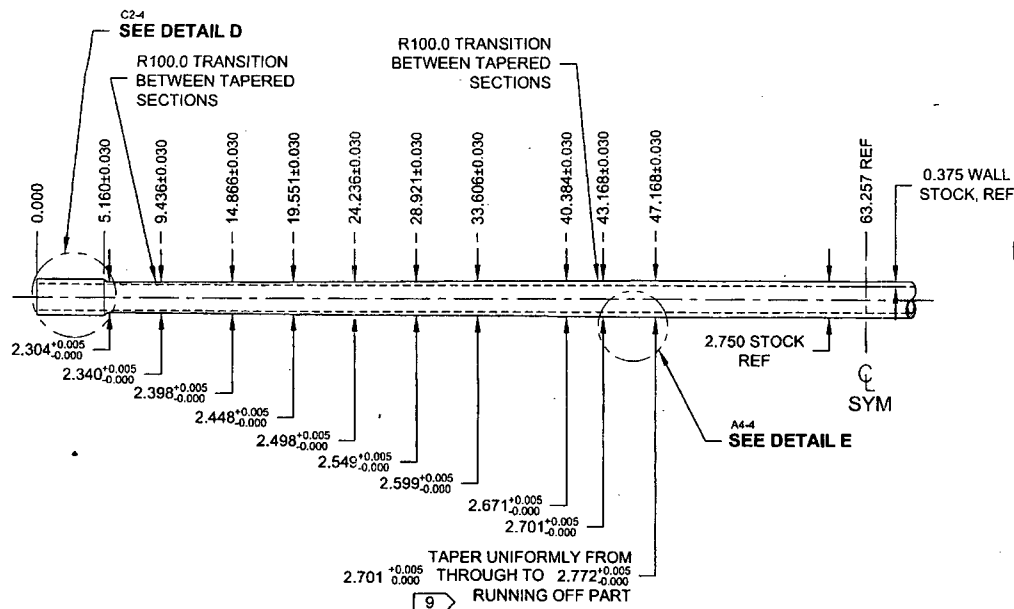
**VIEW C-C: CUFF DETAIL**  
SCALE 3X



**SECTION B-B**  
SCALE 4X

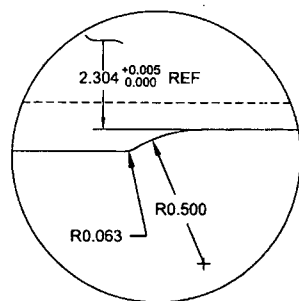
64541  
**RELEASED**  
2009-10-29  
MP

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D212-664-141	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	TUBE ASS'Y (205/212/412 HI FWD)	NTS
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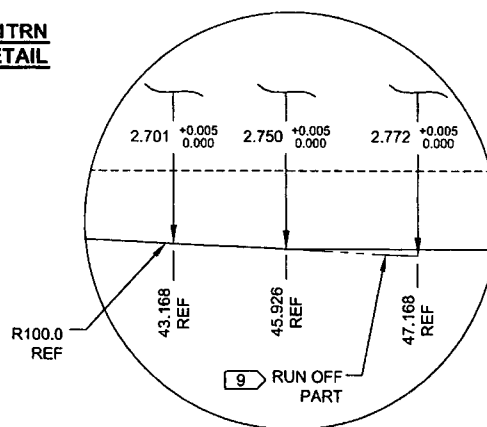


**DETAIL D:**  
**CROSSTUBE CUFF** D6-4  
SCALE 5X

**D212-664-141TRN**  
**TURNING DETAIL**



**DETAIL F:**  
**CUFF TRANSITION** C2-4  
SCALE 10X



**DETAIL E:**  
**TAPER RUN-OFF** C2-4  
NOT TO SCALE

64541

**RELEASED**  
2009-10-29

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QD	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 4 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	TH	XTUBE ASSY (205/212/412-H FWD)	NTS
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## Kim Johnston

---

**From:** L Lacelle <llacelle@dartaero.com>  
**Sent:** Wednesday, January 12, 2011 9:04 AM  
**To:** 'Kim Johnston'  
**Subject:** FW: Crosstube corrosion from Expedition

That's for the 2 w/o's you rec'd yesterday

---

**From:** the.sheldons@sympatico.ca [mailto:the.sheldons@sympatico.ca] **On Behalf Of** Susanne Sheldon  
**Sent:** January 12, 2011 8:22 AM  
**To:** 'L Lacelle'  
**Cc:** 'Stow, Dan'; swillems@dartaero.com; 'Marc Bellavance'; 'Jason Murdoch'; 'David Shepherd'; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

I suggest keeping the same batch number and reference the re-work work order on the old work order for traceability  
Susanne

---

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** January 11, 2011 8:47 AM  
**To:** 'Susanne Sheldon'  
**Cc:** 'Stow, Dan'; swillems@dartaero.com; 'Marc Bellavance'; 'Jason Murdoch'; 'David Shepherd'; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition  
**Importance:** High

So these have been NDT'd and supports re-installed, all of this was done on w/o's, so my question is, do we send them out under the new B/N ? IF we do, this will screw up our costs of D212-664-101 & -201, as there was no cost entered in the RMA. Any suggestions?

LL

---

**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** January 5, 2011 5:21 PM  
**To:** 'Jason Murdoch'; 'L Lacelle'; 'Marc Bellavance'  
**Cc:** 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

Jason,

I would recommend that we NDT them.

David

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Wednesday, January 05, 2011 1:59 PM  
**To:** 'L Lacelle'; 'Marc Bellavance'  
**Cc:** 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

Will these tubes be NDT'd before they ship back to the customer? I do not want DART being held responsible for any issues that might occur down the road.....ya mean?

**Jason Murdoch**  
**Quality Coordinator**  
[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)  
**DART Aerospace Ltd.**  
**613-632-5200**

---

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Wednesday, January 05, 2011 1:55 PM  
**To:** 'Marc Bellavance'  
**Cc:** 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

With everyone gone for the last couple of weeks no one really touched them. They will get ground today, and alodined and we should be able to ship out by Friday.

LL

---

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** January 5, 2011 1:49 PM  
**To:** 'L Lacelle'  
**Cc:** 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition  
**Importance:** High

Linda,

Where are we with this? Customer wants to know.

**Marc Bellavance**  
**Technical/Shop Support**

***DART*** aerospace Ltd.

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

Web: [www.dartaero.com](http://www.dartaero.com)

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---

**From:** Bill Beckett [mailto:bbeckett@dartaero.com]  
**Sent:** December 20, 2010 12:55 PM  
**To:** 'Peggy McDonald'; swillems@dartaero.com; 'L Lacelle'  
**Cc:** 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'  
**Subject:** RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

Bill

---

**From:** Peggy McDonald [mailto:peggy@darths.com]

**Sent:** December 20, 2010 12:48 PM

**To:** Bill Beckett

**Cc:** Marc Bellavance

**Subject:** Crosstube corrosion from Expedition

**Importance:** High

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.  
(removal of the surface corrosion, acid etch and alodine)

**PLEASE NOTE : the customer will do their own priming right before paint.**

These can be returned to them early in the new year.

I recommend a MISC no charge PO to be sent to DAS.

Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

Peggy

---

**PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056**

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Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

# EXPEDITION HELICOPTERS

61001 Hwy 11 west, P.O. Box 160  
Cochrane, ON P0L 1C0  
Phone: 1-705-272-5755 Fax: 1-705-272-5752  
guylain@expeditionhelicopters.com

Packing Slip	
Packing Slip No.	1285
Date	Dec 3, 2010
Created By	Suzanne
Type	RMA#RA110139 "SQ10210"
Currency	USD
Page 1/1	

## RMA#RA110139 "SQ10210" #1285

<b>To</b> DART HELICOPTER SERVICES 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 CANADA  Tel: 613-632-3336, Fax: 613-632-4443 OR 800-556-4166	<b>Order from</b> 190 HWY 11 WEST PO.BOX 160 COCHRANE,ONTARIO P0L1C0  Tel: (705)-272-5755, Fax: (705)-272-5752
<b>Ship to</b> SAME 190 HWY 11 WEST, PO BOX 160 COCHRANE, ONTARIO P0L 1C0  Tel: (705) 272-5755, Fax: (705) 272-5752	<b>Bill to</b> SAME 190 HWY 11 WEST, PO BOX 160 COCHRANE, ONTARIO P0L 1C0  Tel: (705) 272-5755, Fax: (705) 272-5752

### **\*\* Work to be accomplished at this time \*\***

Please, perform RMA#RA110139 "SQ10210"

### Parts description

Part Number	Description	Tracking #	Ser/Batch #	TTSN	TTSO	Reg	Est. Cost
D212-664-101	CROSSTUBE FWD	11898	B60522			C-FMQN	0.00
<b>Defect</b>	TO BE SENT TO DART HELICOPTERS FOR WARRANTY EVALUATION AS PER JEAN KERR  RETURN AUTHORIZATION #RA110139 "SQ10210"						

Part Number	Description	Tracking #	Ser/Batch #	TTSN	TTSO	Reg	Est. Cost
D212-664-201	CROSSTUBE AFT	11899	B60450			C-FMQN	0.00
<b>Defect</b>	TO BE SENT TO DART HELICOPTERS FOR WARRANTY EVALUATION AS PER JEAN KERR  RETURN AUTHORIZATION #RA110139 "SQ10210"						

  
Signature

  
Date



4650 North Avenue, Oceanside, CA 92056  
Tel: 1-760-295-6094 Fax: 1-760-295-9117  
E-mail: sales@darths.com

## **RETURN AUTHORIZATION**

Date: Dec. 03/10  
To: Expedition Helicopters Inc.  
Attention: Guylain Tremblay  
E-Mail: guylain@expeditionhelicopters.com  
From: Jean

Dear Guylain

Please find below the instructions to return the **D212-664-101/201** ordered on your Purchase Order **2427**.

1. Your Return Authorization Number is **RA110139**. Please make reference to this number on all paperwork. Items must still be in original packaging. Please label the crosstubes with "**SQ10210**".
2. The Original Release Certificate, STC's, Installation Instructions, Maintenance Manual Supplement, Flight Manual Supplement, and packing slips must accompany the shipment.
3. Please mark the shipping labels to:  
Dart Aerospace,  
1270 Aberdeen Street,  
Hawkesbury, Ontario.  
Canada K6A 1K7  
Tel.: 1-613-632-5200
4. Brad from Journey Freight (tel 514-447-0242, ext. 3242) will contact you for the pick up of the crosstubes. This Return Authorization expires in 30 days. The Quality Control at Dart Aerospace will evaluate the crosstubes and will notify you once completed.

If you require additional information, please feel free to contact us. **DART HELICOPTER SERVICES, LLC** is always pleased to assist you with your helicopter needs.

Best Regards,

Jean Kerr  
Sales Support  
**DART HELICOPTER SERVICES, LLC**





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 5200  
Fax: 613 632 5246

# Packing Slip

Packing Slip Number : INV102995

Customer Purchase Order ID : 7601/2427

Sales Order ID : SO103029

Ship Date : 8/24/2010 12:58:00 PM

Page Number : 2

Bill To : CU-DAR001

DART HELICOPTERS SERVICES LLC.  
1736 ORD WAY  
OCEANSIDE, CA 92056  
US

Ship To :

EXPEDITION HELICOPTERS, INC.  
190 HWY 11 WEST  
COCHRANE, ON P0L 1C0  
CA

Buyer:

Contact Name: Suzanne Arsenaault

Contact Phone: 705 272 5755

Contact Phone Ext.:

Order Date: 8/24/2010 12:46:25 PM  
Manitoulin Ground Coll

FOB: Territory: CA Central

Ship From: MAIN WAREHOUSE

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7 CANADA

Bill of Lading :

Pallets 0  
Cartons 0  
Weight 0

Ship From Phone: 613 632 5200

Line /	Item ID /	Item Name	Harmonize Code:	Req. Date	Req. Qty	Ship Qty	Backordered Qty
Cust PO Line Nbr	Cust Item ID						
4	D205-634-011		8803.20	8/24/2010	1.0000	1.0000	0.0000
4	Skidtube				Each	Each	

Special  
Instructions:

Lot Number  
60690

Lot Trans Qty  
1.0000

As per FAA STC requirement, this is written evidence that Dart Aerospace Ltd. gives the above Ship-to permission to use the STC(s) for the above shipped part(s) to alter the product listed in the STC(s).

Special  
Instructions for  
Sales Order:



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 5200  
Fax: 613 632 5246

# Packing Slip

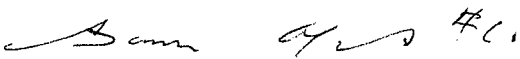
Packing Slip Number : INV102995  
Customer Purchase Order ID : 7601/2427  
Sales Order ID : SO103029  
Ship Date : 8/24/2010 12:58:00 PM  
Page Number : 1


<b>Bill To :</b> CU-DAR001 DART HELICOPTERS SERVICES LLC. 1736 ORD WAY OCEANSIDE, CA 92056 US	<b>Ship To :</b> EXPEDITION HELICOPTERS, INC. 190 HWY 11 WEST COCHRANE, ON P0L 1C0 CA
<b>Buyer:</b>	<b>Contact Name:</b> Suzanne Arseneault <b>Contact Phone:</b> 705 272 5755 <b>Contact Phone Ext.:</b>
<b>Order Date:</b> 8/24/2010 12:46:25 PM <b>Bill of Lading :</b>	<b>FOB:</b> Origin Manitoulin Ground Coll <b>Territory:</b> CA Central <b>Pallets:</b> 0 <b>Cartons:</b> 0 <b>Weight:</b> 0
	<b>Ship From:</b> MAIN WAREHOUSE DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA <b>Ship From Phone:</b> 613 632 5200

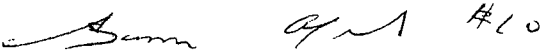
Line / Cust PO Line Nbr	Item ID / Cust Item ID	Item Name	Harmonize Code:	Req. Date	Req. Qty	Ship Qty	Backordered Qty
1	D212-664-101		8803.20	8/24/2010	1.0000	1.0000	0.0000
1	Crosstube Fwd				Each	Each	
Special Instructions:			<u>Lot Number</u> 60522			<u>Lot Trans Qty</u> 1.0000	
2	D212-664-201		8803.20	8/24/2010	1.0000	1.0000	0.0000
2	Crosstube Aft				Each	Each	
Special Instructions:			<u>Lot Number</u> 60450			<u>Lot Trans Qty</u> 1.0000	
3	D205-634-011		8803.20	8/24/2010	1.0000	1.0000	0.0000
3	Skidtube				Each	Each	
Special Instructions:			<u>Lot Number</u> 59280			<u>Lot Trans Qty</u> 1.0000	


As per FAA STC requirement, this is written evidence that Dart Aerospace Ltd. gives the above Ship-to permission to use the STC(s) for the above shipped part(s) to alter the product listed in the STC(s).

Special  
Instructions for  
Sales Order:

<b>1. Approving Civil Aviation Authority/Country:</b> <b>Transport Canada</b>		<b>2. AUTHORIZED RELEASE CERTIFICATE</b> <b>FORM ONE</b>				<b>3. Form Tracking No:</b> SO103029-2	
<b>4. Organizations Name and Address:</b>		DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada			Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com		<b>5. Work Order/Contract/Invoice</b>  7601/2427
<b>6. Item:</b>	<b>7. Description:</b>	<b>8. Part No:</b>	<b>9. Quantity:</b>	<b>10. Serial/Batch No:</b>	<b>11. Status/Work:</b>		
1	Crosstube Aft	D212-664-201	1	B60450	New		
<b>12. Remarks:</b> TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06							
<b>13a. Certifies that the items identified above were manufactured in conformity to:</b> <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			<b>14a.</b> <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.				
<b>13b. Signature:</b> 		<b>13c. Approved Organization Number:</b>  9-89	<b>14b. Signature:</b>  N/A		<b>14c. Approved Organization Number:</b>  N/A		
<b>13d. Name:</b> Suzanne Bedford		<b>13e. Date (dd/mm/yyyy):</b> 24/Aug/2010	<b>14d. Name:</b>  N/A		<b>14e. Date (dd/mm/yyyy):</b>  N/A		
(Previously form 24-0078)							
Important: See notes							
<b>This certificate does not constitute authority to install.</b>							
<b>Installer Responsibilities</b>							
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.							
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							

1. Approving Civil Aviation Authority/Country: <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE</b> <b>FORM ONE</b>			3. Form Tracking No: SO103029-1	
4. Organizations Name and Address:		DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada			Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com	
		5. Work Order/Contract/Invoice 7601/2427				
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:	
1	Crosstube Fwd	D212-664-101	1	B60522	New	
12. Remarks: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12			
<input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature:		13c. Approved Organization Number:	14b. Signature:		14c. Approved Organization Number:	
		9-89	N/A		N/A	
13d. Name:		13e. Date (dd/mm/yyyy):	14d. Name:		14e. Date (dd/mm/yyyy):	
Suzanne Bedford		24/Aug/2010	N/A		N/A	
(Previously form 24-0078)						
Important: See notes						
<b>This certificate does not constitute authority to install.</b> <b>Installer Responsibilities</b> Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

1. Approving Civil Aviation Authority/Country: <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE</b> <b>FORM ONE</b>			3. Form Tracking No: SO103029-4	
4. Organizations Name and Address: DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada				Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com		
5. Work Order/Contract/Invoice 7601/2427						
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:	
1	Skidtube	D205-634-011	1	B60690	New	
12. Remarks: TC STC SH96-88 Issue 3, FAA STC SR00563NY 08/08/11, EASA STC EASA.IM.R.S.01303 07/06/27, JCAB JAPAN STC-55-1-TYO 99/11/24						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature: 		13c. Approved Organization Number: 9-89	14b. Signature: N/A		14c. Approved Organization Number: N/A	
13d. Name: Suzanne Bedford		13e. Date (dd/mm/yyyy): 24/Aug/2010	14d. Name: N/A		14e. Date (dd/mm/yyyy): N/A	
(Previously form 24-0078)						
Important: See notes						
<p>This certificate does not constitute authority to install.</p> <p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

1. Approving Civil Aviation Authority/Country: <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE</b> FORM ONE			3. Form Tracking No: SO103029-3		
4. Organizations Name and Address: DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada		Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com			5. Work Order/Contract/Invoice 7601/2427		
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:		
1	Skidtube	D205-634-011	1	B59280	New		
12. Remarks: TC STC SH96-88 Issue 3, FAA STC SR00563NY 08/08/11, EASA STC EASA.IM.R.S.01303 07/06/27, JCAB JAPAN STC-55-1-TYO 99/11/24							
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature: 		13c. Approved Organization Number: 9-89		14b. Signature: N/A		14c. Approved Organization Number: N/A	
13d. Name: Suzanne Bedford		13e. Date (dd/mm/yyyy): 24/Aug/2010		14d. Name: N/A		14e. Date (dd/mm/yyyy): N/A	
(Previously form 24-0078)							
This certificate does not constitute authority to install.							
<b>Installer Responsibilities</b> Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							
Important: See notes							



File D

**L Lacelle**

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** January 5, 2011 5:21 PM  
**To:** 'Jason Murdoch'; 'L Lacelle'; 'Marc Bellavance'  
**Cc:** 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

Jason,

I would recommend that we NDT them.

David

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Wednesday, January 05, 2011 1:59 PM  
**To:** 'L Lacelle'; 'Marc Bellavance'  
**Cc:** 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

Will these tubes be NDT'd before they ship back to the customer? I do not want DART being held responsible for any issues that might occur down the road.....ya mean?

**Jason Murdoch**  
**Quality Coordinator**  
 jmurdoch@dartaero.com  
 DART Aerospace Ltd.  
 613-632-5200

*How to ship  
New B/W?*

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Wednesday, January 05, 2011 1:55 PM  
**To:** 'Marc Bellavance'  
**Cc:** 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition

With everyone gone for the last couple of weeks no one really touched them. They will get ground today, and alodined and we should be able to ship out by Friday.

LL

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** January 5, 2011 1:49 PM  
**To:** 'L Lacelle'  
**Cc:** 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'  
**Subject:** RE: Crosstube corrosion from Expedition  
**Importance:** High

Linda,

1/06/11



Where are we with this? Customer wants to know.

**Marc Bellavance**

**Technical/Shop Support**

***DART aerospace Ltd.***

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

Web: [www.dartaero.com](http://www.dartaero.com)

**Product Documentation: Verify Revision Status/Download [HERE!](#)**



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**From:** Bill Beckett [<mailto:bbeckett@dartaero.com>]

**Sent:** December 20, 2010 12:55 PM

**To:** 'Peggy McDonald'; [swillems@dartaero.com](mailto:swillems@dartaero.com); 'L Lacelle'

**Cc:** 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'

**Subject:** RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

**Bill**

**From:** Peggy McDonald [<mailto:peggy@darths.com>]

**Sent:** December 20, 2010 12:48 PM

**To:** Bill Beckett

**Cc:** Marc Bellavance

**Subject:** Crosstube corrosion from Expedition

**Importance:** High

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.  
(removal of the surface corrosion, acid etch and alodine)

**PLEASE NOTE : the customer will do their own priming right before paint.**

These can be returned to them early in the new year.

I recommend a MISC no charge PO to be sent to DAS.

Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

1/06/11

Peggy

---

**PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056**

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1/06/11

# List Lots

January 5, 2011 3:20:21 PM

Page 1 of 1

Criteria : All Items All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
----------------------	-----------------------------	------------	-----------------	---------	---------------	-----------	----------

D212-664-201CM	Main Warehouse	60450	12/14/10	1.0000			
Crosstube, customer mat'l	RMAInspect						

Total: 1.0000

64547

RA 110731

# List Lots

January 5, 2011 3:20:06 PM

Page 1 of 1

Criteria : All Items All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		

D212-664-101CM	Main Warehouse	60522	12/14/10	1.0000			
Crosstube, customer mat'l	RMAInspect						

Total: 1.0000

64541

\* Customer Property \*

Do Not Damage

24116134 For investigation  
to Washington

Wet 10-380  
5010210

1/10/2002

\* Customer Property \*

Do Not Damage

24116134 For investigation

to Washington

Wet 10-380  
5010210

1/10/2002